Select 81-Ni2

Description:

- A low alloy steel, flux cored, gas shielded electrode for welding in the flat and horizontal positions
- Intended for use with 100% CO_2 shielding gas
- Arc transfer is a smooth, small droplet spray
- The 2.5% nickel deposit is ideal for welding steels such as ASTM A203, A572, A575, and A734
- This electrode is well suited for offshore platform construction, mining machinery, and shipbuilding applications

Classification:

E80T1-Ni2C per AWS A5.29, ASME SFA 5.29
E80T1-C1A4-Ni2 per AWS A5.36, ASME SFA5.36

Typical Mechanical Properties:

	100% CO_2
Ultimate Tensile Strength (psi)	89,300
Yield Strength (psi)	76,500
Percent Elongation	27
CVN (ft·lbf) @-40ºF	48

Typical Deposit Composition:

Wt%	C	Mn	Si	P	S	Ni
	.07	1.00	.29	.010	.010	2.23

Recommended Welding Parameters:

	Optimum			Range	
Diameter	Amperage	WFS	Voltage	Amperage	Voltage
1/16"	350	300	29	150-400	22-34
5/64"	390	250	29	280-430	26-33
3/32"	450	210	31	300-550	26-34

Rev 1 (02/11/2019)